

# Work Order ID 52279

Tuesday, September 22, 2009 1:26:34 PM



Page 1

|                            |                 |  |               |       |  |
|----------------------------|-----------------|--|---------------|-------|--|
| Item ID: D3874-1           | Accept          |  | Setup         | Start |  |
| Revision ID: A             |                 |  |               | Stop  |  |
| Item Name: Floor Protector |                 |  |               |       |  |
| Start Date: 9/23/2009      | Start Qty: 5.00 |  | Cust Item ID: |       |  |
| Required Date: 10/6/2009   | Req'd Qty: 5.00 |  | Customer:     |       |  |
| Reference:                 |                 |  |               |       |  |

|            |                         |                       |            |       |
|------------|-------------------------|-----------------------|------------|-------|
| Approvals: | Process Plan: <u>MF</u> | Date: <u>09/29/24</u> | Tooling:   | Date: |
|            | QC:                     | Date:                 | SPC (Y/N): | Date: |

|     |       |  |
|-----|-------|--|
| Run | Start |  |
|     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

|          |              |
|----------|--------------|
| Draw Nbr | Revision Nbr |
| D3874    | Rev A        |

|     |      |
|-----|------|
| 100 | 0.00 |
|-----|------|



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

09/30/09  
BB X10

|     |      |
|-----|------|
| 110 | 0.00 |
|-----|------|



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9453  
Dwg Rev: A  
Folio Rev: A

09/30/09  
BB X10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3874-1 PAR #: \_\_\_\_\_ Fault Category: Prod Thermforming NCR: Yes No DQA: [Signature] Date: 08.15.14  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 09.10.14

| NCR: <u>52279</u> |            | WORK ORDER NON-CONFORMANCE (NCR)   |                             |   |                                       |                                       |                                       |                                       |
|-------------------|------------|--|-----------------------------|---|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
| DATE              | STEP       | Description of NC<br>Section A   | Corrective Action Section B |   |                                       | Verification<br>Section C             | Approval<br>Chief Eng                 | Approval<br>QC Inspector              |
|                   |            |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng   | Sign &<br>Date                        |                                       |                                       |                                       |
| <u>9/16/05</u>    | <u>#10</u> | <u>trimming error. operator too</u><br><u>quickly held tool level</u><br><u>control of air saw while</u><br><u>trimming</u><br><u>R.L. Process/human error</u> | <u>[Signature]</u>          | <u>-Scrap and destroy no</u><br><u>Replace. Marks are no</u><br><u>need to be</u><br><u>use as reference mark if</u><br><u>Identify as reference.</u> | <u>[Signature]</u><br><u>09/16/05</u> | <u>[Signature]</u><br><u>09/16/05</u> | <u>[Signature]</u><br><u>09/16/05</u> | <u>[Signature]</u><br><u>09/16/05</u> |
|                   |            |  |                             |   |                                       |                                       |                                       |                                       |
|                   |            |  |                             |   |                                       |                                       |                                       |                                       |

NOTE: Date & initial all entries

**Work Order ID 52279**

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Item ID: D3874-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 9/23/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visuallly inspect part for proper formation and texture

09/30/09  
BB X10

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

09/10/05  
BB X10

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

①

09/10/05  
BB X9

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Page 3

Item ID: D3874-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 9/23/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

①

09/10/05

BB ①⑨

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/8 09/10/05

①⑨

①⑨

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

2/10/07 ①⑨ SP

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Item ID: D3874-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 9/23/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/08 *[Signature]**W 9.10.08*

# Picklist Print

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Work Order ID: 52279



Parent Item: D3874-1RevA



Parent Item Name: Floor Protector

Start Date: 9/23/2009

Required Date: 10/6/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MLEXS.118-90318-08              |                        | Purchased     | No          |                     |                  | 100             | sf                 | 445.6200       | 21.9000                  |               |                |        |



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

445.62

111588

445.62

M111588

B0X1Q

|                              |        |                      |
|------------------------------|--------|----------------------|
| DART AEROSPACE LTD           |        | Work Order: 52279    |
| Description: Floor Protector |        | Part Number: D3874-1 |
| Inspection Dwg: D3874        | Rev: A | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

| Description   | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than "  | ✓      |        |                      |          |
| Shape Definition  | ✓      |        |                      |          |
| Texture Retention   | ✓      |        |                      |          |
| Material imperfections such as bumps, cracks, voids, scratching | ✓      |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |

Measured by: BB. Date: 09/30/09

### TRIMMING SECTION

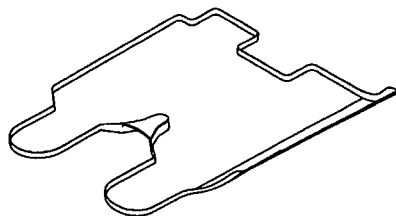
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.050             | Min       | .096             | ✓      |        |                      |          |
| 0.065             | Min       | .104             | ✓      |        |                      |          |
| 0.5               | Min       | .519             | ✓      |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |

Measured by: BB. Date: 09/30/09

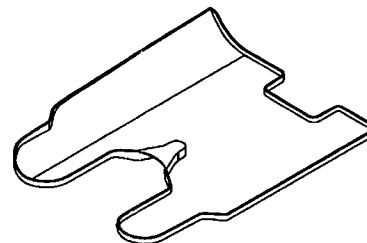
Audited by: OK. Date: 09/30/09

Prototype Approval: N/A Date: N/A

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 09.09.15 | New Issue | KJ         | AA       |



**D3874-1 FLOOR PROTECTOR**



**D3874-2 FLOOR PROTECTOR**

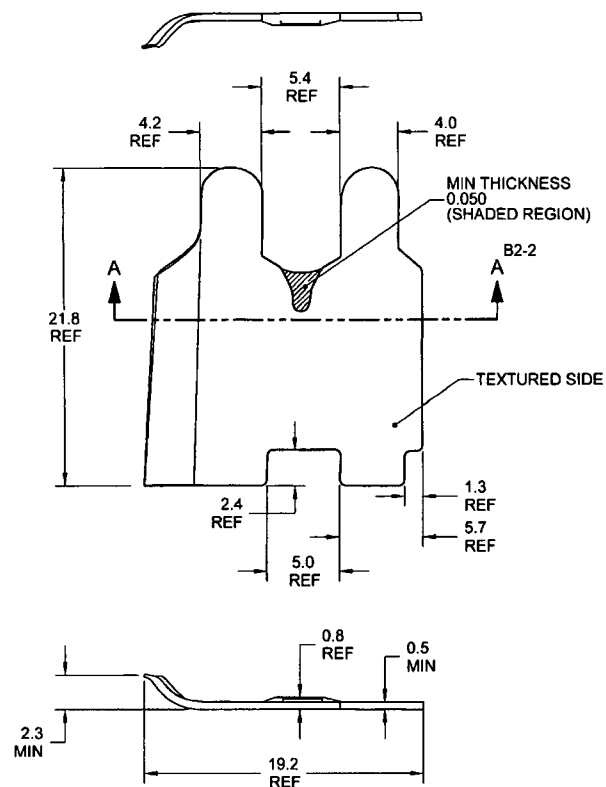
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52279

**RELEASED**  
09/05/05

|            |             |   |              |
|------------|-------------|---|--------------|
| A          | NEW ISSUE   | PH  | 09.01.29     |
| REV.       | DESCRIPTION | BY  | DATE         |
| DESIGN     | PH          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | PH          |   |              |
| CHECKED    |             | DRAWING NO.   | REV. A       |
| MFG. APPR. |             | <b>D3874</b>  | SHEET 1 OF 3 |
| APPROVED   |             | TITLE   | SCALE        |
| DE APPR.   |             | <b>FLOOR PROTECTOR</b>  | NTS          |
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**SECTION A-A**  
SCALE 2X

**D3874-1 FLOOR PROTECTOR**

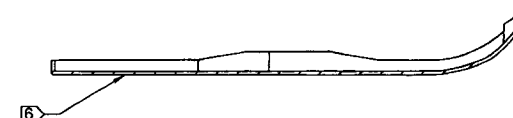
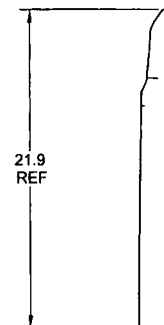
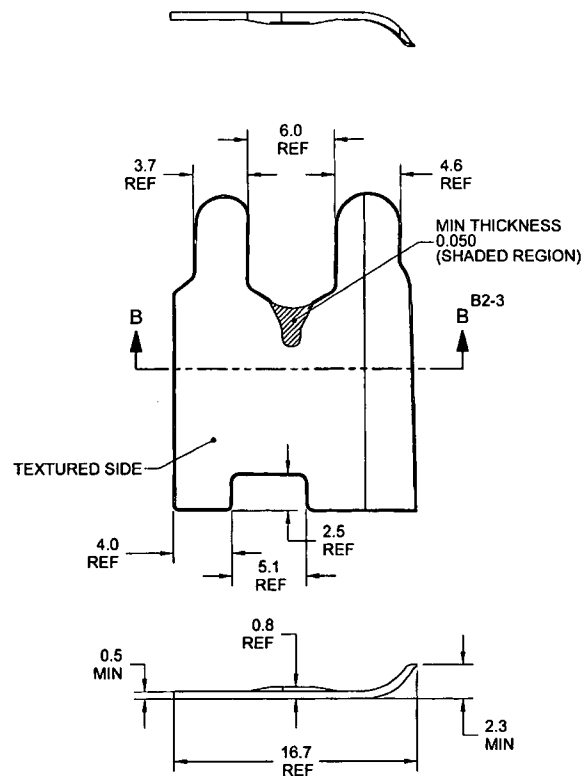
**RELEASED**  
8/25/54

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

|  |           |  |              |
|--|-----------|--|--------------|
| DESIGN   | <i>PH</i> | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  | <i>PH</i> | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | <i>PH</i> | DRAWING NO.                            | REV. A       |
| MFG. APPR.   | <i>PH</i> | D3874                                  | SHEET 2 OF 3 |
| APPROVED   | <i>PH</i> | TITLE                                  | SCALE        |
| DE APPR.   | <i>PH</i> | FLOOR PROTECTOR                        | NTS          |
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SECTION B-B  
SCALE 2X

# **D3874-2 FLOOR PROTECTOR**

## **NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   | Per      | DART AEROSPACE LTD                     |              |
| DRAWN  | Per      | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | Per      | DRAWING NO.                            | REV. A       |
| MFG. APPR.   | Per      | D3874                                  | SHEET 3 OF 3 |
| APPROVED   | Per      | TITLE                                  | SCALE        |
| DE APPR.   | Per      | FLOOR PROTECTOR                        | NTS          |
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RELEASED  
9/15/09